

5/30

DART AEROSPACE LTD	Work Order:	23731
Description: Cover	Part Number:	D3202-1
Dwg: D3202 Rev. B1	Qty:	33
Ref:		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JK	05.07.04	30
2	PG	Issue P/O: <u>2009316</u> Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3202 Possible Supplier: GFI or Industrial Laser Material release note is required			
3	RG	Receive and Inspect for transit damage Ensure material release note is attached	DL	05/09/11	33
4	QC6	Inspect dimensions as per Dwg D3202	SB	05/08/15	33
5	GA	Deburr	SAP	05/08/15	32
6	FP	Chemical Conversion Coat as per QSI-005.4.1	SAP	05/08/18	32
7	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3	FC	05/08/24	32
8	QC3	Inspect Powder Coat	ML	05/08/26	32
9	ST	Identify and Stock	DL	05/08/26	33
10	AC	Cost / part: <u>33,05</u>	SAC	05.08.28	33
11	DC	Close W/O <u>32,59</u> Inspect Level 21	JK	05/08/21	33

Rev	Date	Change	Revised By	Approved
A	03.11.07	New issue	KJ/RF	
B	04.10.21	Laser Cut no longer made in-house	KJ/JLM	JK

RELEASED
04.10.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: 

Date: 05/08/29

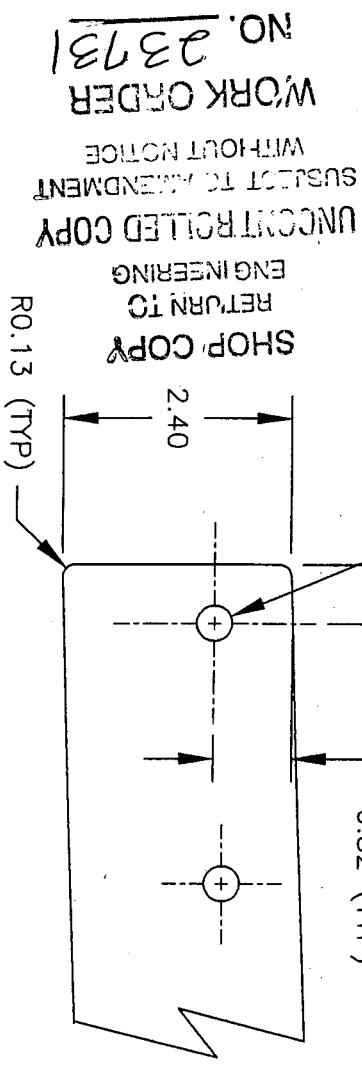
NOTE: Date & initial all entries

QA: N/C Closed: _____

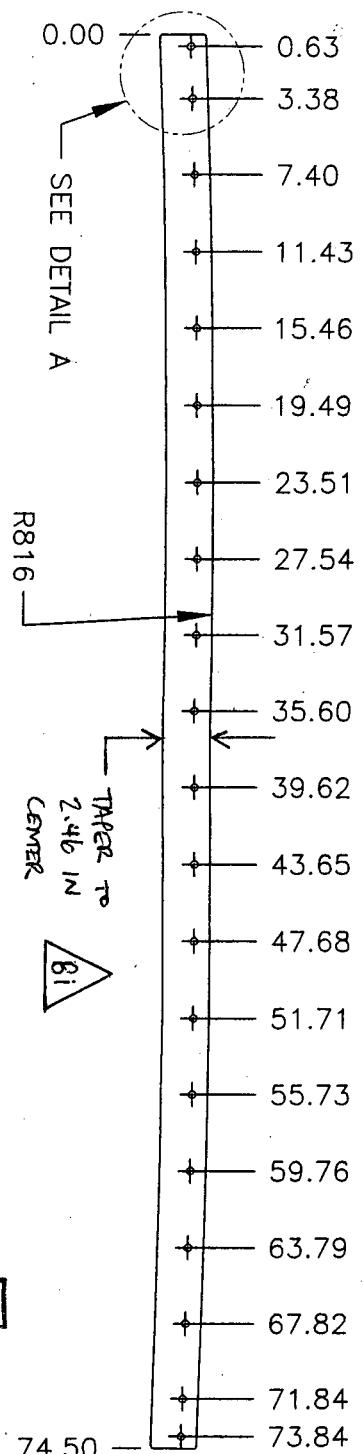
Date: _____

D3202-1 COVER

- 1) MATERIAL: 5052-H32/H34 SHEET (QQ-A-250/8) 0.032 THICK (REF DART SPEC. M5052H32S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010



03.11.07 44
RELEASED
DETAIL A
SCALE 1:2



DESIGN	DRAWN BY	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3202
DATE	TITLE	REV. B
03.10.16	COVER	SCALE 1:10
A	01.01.01	NEW ISSUE
B	03.10.16	REDESIGN; PART NOW CURVED
B1	04.05.14	CLARIFY MD-SHAPE DIMENSION

COPIED
BY ISSUE

DART

Job Costing Report

Dart Aerospace Ltd.
HawkesburyJun 30, 2005
02:06 pm

Work Order No : 0023731
 Project Name : D3202-1
 Project For : WK530
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3202-1
 Description : Cover
 Manufactured : Yes
 Amount Req'd : 30
 Amount Done : 0
 Start Date : 06-30-05
 Est Finish Date : 07-30-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Mark Up : 0.000%
 Actual Mark Up : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	0.00	0.00	0.00		
<hr/>					
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/ (Loss)	0.00	0.00

MATERIAL TEST REPORT

From: PECHINEY ROLLED PRODUCTS
CENTURY ROAD
P.O. BOX 68
RAVENSWOOD, WV , 26164

Page : 1
Heat/Lot : 351511
TIN : 351511

Sold To: INTEGRIS METALS, LTD.
12311 HORSESHOE WAY
RICHMOND , BC V7A 4X6

Ship To: 3399 FRANCIS HUGHES
LAVAL PQ
--H7L 5

Vendor Information

Cust PO #: 78597

Cust PO DT: 04/05/05

Specifications

RAVENSWOOD DISTRIBUTOR
SPEC COIL NON HT MILL
AMS-QQ-A-250/8
ALSO CONFORMS TO ASTM B209-04
Buyer Part: 54582309

5052-H32 0.32 IN 14.5 IN

Mechanical Tests

	Min	UOM	L	O	Max	UOM	L	O
Number of Tests: 2								
Ult Tensile Str, Longitudinal	34.2	KSI		LONG	35.6	KSI		LONG
Yield Strength	26.9	KSI		LONG	29	KSI		LONG
Elongation, Longitudinal	9.5	PCT		LONG	12	PCT		LONG

Chemical Composition

SI	Silicon-Pct	.150	FE	Iron-Pct	.200
CU	Copper-Pct	.040	MN	Manganese-Pct	.050
MG	Magnesium-Pct	2.420	CR	Chromium-Pct	.170
ZN	Zinc-Pct	.010	OE	Others Each Max-Pct	.050
OT	Others Tot Max-Pct	.150		Al Remainder-Pct	

Comments

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Page : 2
Heat/Lot : 351511
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CERTIFICATION

Pechiney Rolled Products / Ravenswood Operations certifies that metal shipped under this order has been inspected and tested and found in conformance with the requirements of the applicable specifications as indicated herein. any warranty is limited to that shown on PRP(s) standard General Terms and Conditions of Sales. Test reports are on file, subject to examination

PECHINEY ROLLED PRODUCTS
RAVENSWOOD OPERATIONS - RAVENSWOOD, WV. 26164

QA by MARK PARSONS 03/16/2005

Miscellaneous Data

Control #: 90263879 Date: 07/27/05
S.O. Number :590 365410 4
AL SHT TL OOA250/8 5052H32

Customer P.O.: 227136

The Chemical Analysis and Mechanical Test data was received via EDI from the above mentioned vendor.

INTEGRIS METALS, LTD.